

Date: Monday, 6/5/2006 11:00:19 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 STEP ASSY LH *UNDER REVIEW**
Job Number	: 27398		
Estimate Number	: 12438		
P.O. Number	: N/A	Part Number	: D058677011
This Issue	: 6/5/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2943 UNDER REVIEW 6
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: UNDER 6
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/12/2006
Checked & Approved By	: <u>06.06.05</u>	Qty:	4 Um: Each
Comment	: Est Rev: 01.04.11 Combined with D2943-041 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD058-677-011	CHG	<u>KS 06.06.07. (4)</u>
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2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit	Total: 4.0000 Each(s)
Extrusion D2622-120C	
Batch: <u>327077</u>	

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit	Total: 8.0000 Each(s)
D2734 206 Step Endplate	
Batch: <u>324402</u>	

4.0	D2725	206 Step Lug
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Comment: Qty.: 1.0000 Each(s)/Unit	Total: 4.0000 Each(s)
D2725 206 Step Lug	
Batch: <u>320763</u>	

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943	<u>KS 06.06.05</u>	4
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2-Deburr and bevel ends for welding	<u>KS 06.06.05</u>	4
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3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482	<u>KS 06.06.06</u>	4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:00:19 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 27398

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R AL ROD

Batch: M19173
M15689

4-Grind end cap welds flush as per dwg D2943

SE. 06.06.06

FF 06.06.06

PD 06-06-06 (4)

6.0

QC5/9

WELD INSPECTION



06-06-06 (4)



Comment: WELD INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.06.06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: M15689

2-Grind end cap welds flush as per dwg D2943

SE. 06.06.06

FF 06.06.06

PD 06-06-07

10.0

QC5/9

WELD INSPECTION



06-06-07 (4)



Comment: WELD INSPECTION

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/07

(4)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-06-07

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 27398

Part Number: D058677011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M100652

06-06-07

09

14.0	QC3/5	INSPECT WORK/WING WALK
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Comment: INSPECT WORK/WING WALK

FC 06 06 08

09

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0	D27311	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B9761x6 - B15282x2 -

17.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

B14652x4 - B20641x4

18.0	D27315	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B20615 x4 B26735 x4

19.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Batch: B22592

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/01/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27398

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: m17771 ✓

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

m19551 x 12 1/2 m100651 x 12 ✓

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

Batch: m19085 ✓

AR 06/06/06 (4)

23.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

Batch: Duplicate Step.

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AR 06/06/08 (4)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location: PG24

PPP Rev: B AR 06/06/08 (4)

26.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

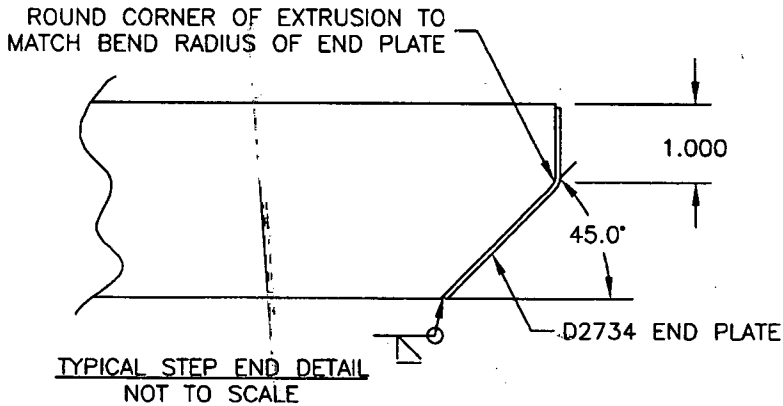
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

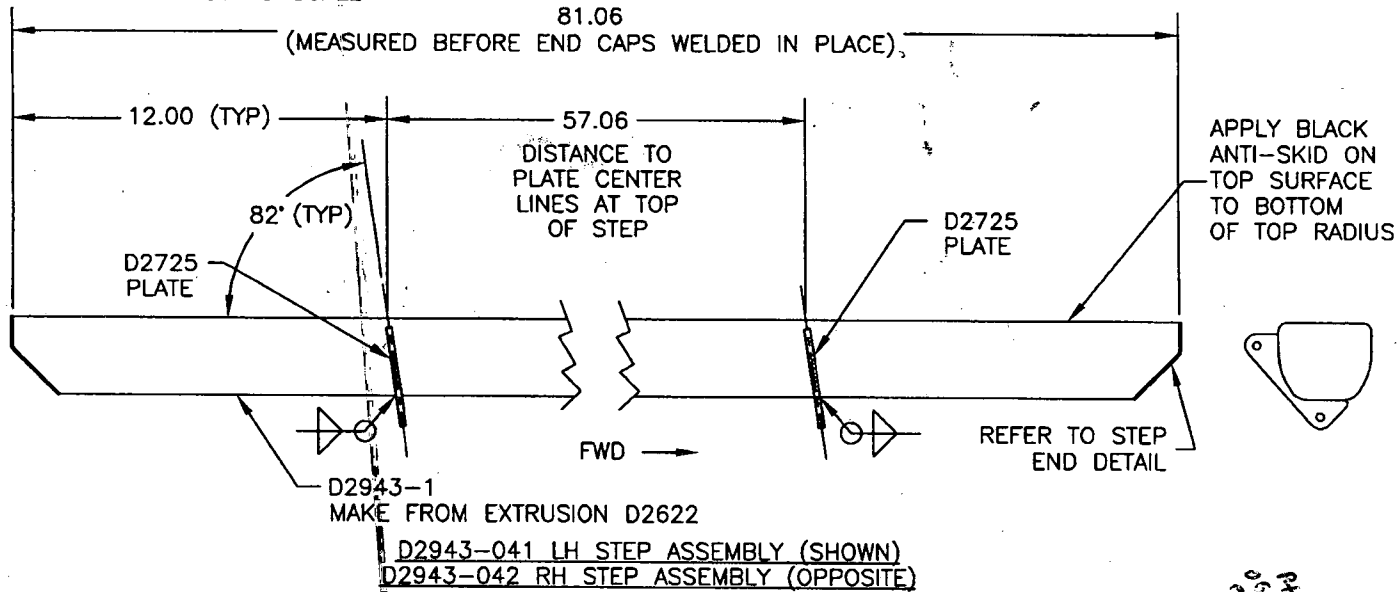
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

05.11.28-11

UNDER REVIEW

PH 05-05 → RE-DESIGN
06-02-1953
FOR LINDA TO
WILEY
12-06-53

DESIGN	RF	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	05.11.14			D2943	SHEET 1 OF 1
				TITLE	SCALE
				OH-58 STEP ASSEMBLY	NTS
A		99.11.19		NEW ISSUE	
B		05.11.14		UPDATE FINISHING NOTE	

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